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(54) BLANKING METHOD WITH PROGRESSIVE FEED

(57) Abstract:

PURPOSE: To perform drawing and finishing by shaving with one process in the stage of blanking a base material by blanking the base material without disconnecting the works including shaving allowances from the base material then subjecting the works to shaving.

CONSTITUTION: A base material 4 is subjected with progressive feed to formation of positioning holes 5, blanking of unnecessary parts 6 and drawing for forming a projecting part 2 of the product in the 1stW9th stages. The projecting part 2 is formed on the outside circumference of a product forming part 1' by means of a punch 7 for projection, a punch 8 and a knockout 9 in the stage of leaving a shaving allowance S to said part in a way as to avoid generation of a rupture between said part and the base material 4 in the 10th stage. A through-hole 3 is blanked in the 11th stage and the outside circumference of the part 1' is subjected to shaving by a punch 9 and a die 10 for shaving in

the 12th stage. The product 1 having the shaved surface 1a without disconnecting shaving scrap 11 from the base material is obtd.

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